

## **Experimental Mill (X-Mill) Environmental Policy Statement**

We are committed to preserving and protecting the environment by:

1. Complying with all relevant environmental legislation, regulations, permits or consents, and Kimberly-Clark corporate environmental objectives.
2. Monitoring, controlling, and continuously improving performance relative to waste generation, air emissions, water discharges, energy usage, and response procedures.
3. Training employees on their roles to assist in maintaining a facility that is environmentally compliant.

### **Stormwater Pollution Prevention**

#### **Current Best Management Practices**

- Conduct a comprehensive site compliance evaluation at least annually. Visually inspect drainage systems, structural measures, and other pollution prevention measures that have been identified.
- Conduct quarterly visual inspections
- Conduct a Storm Water Assessment and Certification two times per year
- Sweep entire parking lot after melting of last snow fall and on an as needed basis
- Inspect and clean grounds on a weekly basis during non-snow periods
- Maintain shoreline Rip-Rap
- Utilize “Area Drain Control Procedures” for unloading docks at Doors B, C, D, and E, Sub-Station and Millview warehouse for Stormwater containment and control. Inspect containment/control systems on a quarterly basis for operating integrity.
- Clean and inspect area surrounding the refuse compactor periodically
- Inspect the compactor hydraulic system for leaks on a weekly basis
- Affected personnel receive Stormwater certification training every 3 years

### **Spill Prevention and Countermeasure Control**

#### **Current Best Management Practices**

- Inspect the chemical waste accumulation area and hazardous waste satellite area weekly for leaks and container integrity.
- Inspect maintenance oil storage area weekly for leaks and container integrity
- Inspect TAD 1 & 2 lube oil area weekly for leaks
- Inspect ECU 1&2 hydraulic supply area weekly for leaks
- Affected personnel receive RCRA and HAZWOPER refresher training annually
- Sulfuric Acid SOP - to address handling and storage

## **Solid Waste Management**

### **Current Best Management Practices**

- Recycle 100% of manufacturing waste
  - Base sheet (tissue broke)
  - Cardboard
  - Poly-wrap
  - Packaging material
  - Plastic buckets(5&1gallon containers)
  - Scrap wood product
- Recycle 100% Universal Waste
  - Lamps and bulbs
  - Used oil
  - Batteries
  - Mercury-containing devices/thermostats
  - Anti-freeze
- Recycle 100% scrap metal waste
- Recycle 100% office waste

## **Air Emissions**

### **Current Best Management Practices**

- X-Mill does not exceed permissible air emission levels
  - Conduct annual air emissions inventory to ensure compliance

## **Past Performance and Improvements**

### **Waste Minimization and Management**

- Replaced the “Safety-Kleen” parts washers with a “Zep” unit that does not require regular servicing and fluid change-outs (fluid was currently treated as hazardous waste). “Zep” manufactures a unit that requires an occasional change-out of a filter (which may be hazardous waste) versus regular disposal of waste fluid.
- Implemented a program to crush and drain aerosol cans and recycle empty cans with scrap metal.
- Implemented a “Total Chemical Management Plan” to manage chemical inventory and reduce Hazardous Waste

### **Energy Reduction Programs**

- Implemented an energy savings plan by shutting off heating, ventilating and air conditioning when building is not occupied. Also shut off make-up air units in the EDU and CHF areas whenever possible. Normally one of the two run when the building is occupied, none when the building is not occupied.

- Energy reduction - 13% in energy usage 2004 to 2005
- In November, 2005, X-Mill and Neenah Paper Inc. began using steam from Minergy Corp. Minergy is helping paper mills meet their long-term environmental goals by burning sludge to produce steam so that it does not go to the landfill. The Minergy plant's steam production has also allowed adjacent paper mills to reduce or eliminate operation of older, less efficient oil and gas-fired boilers, thereby reducing emission levels. Prior to November 2005, gas powered boilers located at Neenah Paper Inc. produced steam for the X-Mill. Landfill elimination for both the X-Mill and Neenah Paper Inc. totals 4,800 tons of sludge per year.

### **Water Reduction Programs**

- Installed a closed loop system on an air compressor
  - Total savings – 6.3 million gallons per year
- Reclaim cooling water from air conditioners for “next day use” in the tissue making process
  - Total savings – 3.8 million gallons per year

### **2006 and Beyond Goals**

- EMS consistent with ISO 14001
  - 100% implemented by 2006 year end
- Continued reduction of water and energy consumption
  - Targeting a project to save 8.4 million gallons in 2006
- Compliant with regulatory reporting requirements
- Compliance with X-Mill Environmental Policy Statement
- Ground Water Remediation/ Site Contamination
  - Continue pump and treat containment effort while working toward site closure.
- Continue waste minimization efforts